

Work Order ID 98155 -2

March-08-13 9:50:54 AM

\*98155\*

Item ID: D4308-042

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Step RH Crew

Start Date: 3/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/29/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 13-03-8

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4308

A

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D4308-1 using D2622 extrusion as per Dwg D4308  
2-Drill, c'sink one hole on top of step as per dwg  
3-Deburr and bevel ends for welding

110

0.00

\*110\*

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

120

0.00

\*120\*

Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 125127  
123928

Large Fab

Memo

0.00

1-Weld end cap (ONE END ONLY)  
2-Grind end cap welds flush  
3-weld lugs as per Dwg D4308

4

0

13-04-16

4

0

DAS  
19  
2-83  
13-04-16

4

0

13-04-17

Work Order ID 98155

March 10, 2013 10:54 AM

98155

Page 2

Item ID: D4308-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Step, RH Crew

Start Date: 3/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/29/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*130\*

QC

Memo

0.00

Quality Control

④

13-04-17

DAS  
09  
2-89

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

④

13-04-17

DAS  
09  
2-89

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

4

13-04-17



Work Order ID: 98155

Mar 4:08:13 9:50:54 AM

\*98155\*

Item ID: D4308-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Step, RH Crew

Stop \*NS2\*

Start Date: 3/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/29/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

\*160\*

QC

Memo

0.00

Quality Control

4

13-04-18

DAS  
19  
2-83  
13-04-18

170

Weld per dwg A/R Aluminum rod Batch: 125127 0.00

Large Fab

\*170\*

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024  
2-Weld Remainig end cap as per Dwg D4308  
3-Grind end cap weld flush as per dwg D2841  
4- install rivert as per dwg

4

13-04-18

13-04-18  
13-04-18

180

QC10- Inspect visual per QSI004- ground welds 0.00

\*180\*

QC

Memo

0.00

Quality Control

13-04-18

13-04-18

DAS  
19  
2-83

Work Order ID 98155

March 08, 11 05:54 AM

\*98155\*

Item ID: D4308-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Step RH Crew

Start Date: 3/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/29/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Quality Control

Memo

0.00

① 13-04-18

DAS  
09  
2-89

200

Chemical Conversion Coat per QSI005 4.1

0.00

\*200\*

HandFinish

Hand Finishing

Memo

0.00

4 13-04-18

212

Spray Painting per QSI005 4.2

0.00

\*212\*

SprayPaint

Spray Painting

Memo

0.00

PRIME B 125132  
DELFLEET BLUE B 123253  
DELFLEET CLEAR B 125633

START TIME: 7:50  
FINISH TIME: 1:15

4

13-05-5



Work Order ID 98155

\*98155\*

Page 5

Item ID: D4308-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Step RH Crew

Start Date: 3/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/29/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

213

QC14- Inspect Spray Paint

0.00

\*213\*

QC

Quality Control

Memo

0.00

DAS 16 13/05/13

42 RH

215

Wing Walk as per dwg QSI005 4.4 Batch 1125314

0.00

\*215\*

HandFinish

Hand Finishing

Memo

0.00

2 RH d 13/05/13

220

QC3- Inspect Part Finish

0.00

\*220\*

QC

Quality Control

Memo

0.00

2 φ 13-05-13

Work Order ID: 98155

\*98155\*

Item ID: D4308-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Step RH Crew

Start Date: 3/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 3/29/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

\*230\*

Packaging

Memo

PPP 99675 0.00

Packaging

4/30/14 (2)

240

QC21- Final Inspection - Work Order Release

0.00

\*240\*

QC

Memo

0.00

Quality Control

13/5/14

mf  
13-5-14



Work Order ID: 06155

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

\*98155\*

\*D4308-042\*

Start Date: 3/08/13

Required Date: 3/29/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.01.07 new issue DD verified

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

75.9700

0.05

0.2

\*D2622-120C\*

Step Extrusion

\*\*

KE 13.04.16

Location

Loc Qty

Loc Code

WA003

75.97

75781

1

81507

4

89750

11.97

93552

59

02

D2734

Manufactured No

120

Each

108.0000

1

4

\*D2734\*

Step End Plate

\*\*

KE 13.04.16

Location

Loc Qty

Loc Code

WA003

108

80682

6

84563

10

91761

32

95395

60

4

D3458-1

Manufactured No

120

Each

45.0000

1

4

\*D3458-1\*

Step Mounting Plate

\*\*

KE 13.04.16

Location

Loc Qty

Loc Code

WA003

45

85693

5

96904

40

4

Work Order ID: 08155

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

\*08155\*

\*D4308-042\*

Start Date: 3/08/13

Required Date: 3/29/13

Start Qty: 4.00

Required Qty: 4.00

D3458-3

Manufactured No

120 Each 49.0000 1 4

\*D3458-3\*

Step Mounting Plate

\*\*

11/13.04.16

Location

Loc Qty

Loc Code

WA003

49

82116

1

93403

20

96905

28

13

D2734

Manufactured No

170 Each 108.0000 1 4

\*D2734\*

Step End Plate

\*\*

11/13.04.18

Location

Loc Qty

Loc Code

WA003

108

80682

6

84563

10

91761

32

95395

60

4

MS20601-AD4W2

Purchased No

170 Each 304.0000 1 4

\*MS20601-AD4W2\*

Rivet

\*\*

11/13.04.18

Location

Loc Qty

Loc Code

ST311

3

122539

1

123900

2

ST506

301

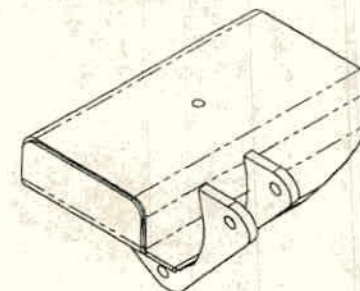
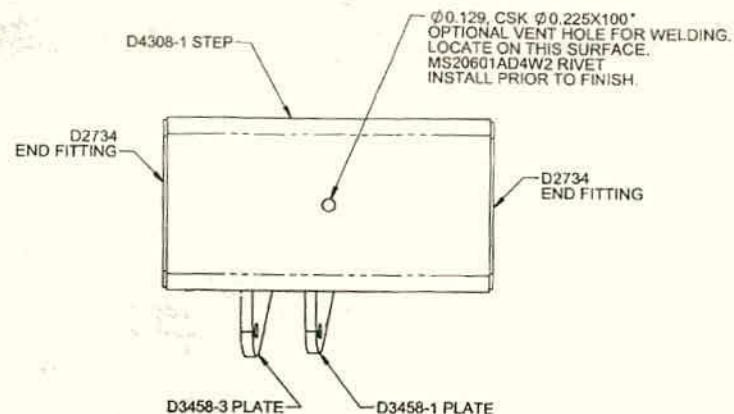
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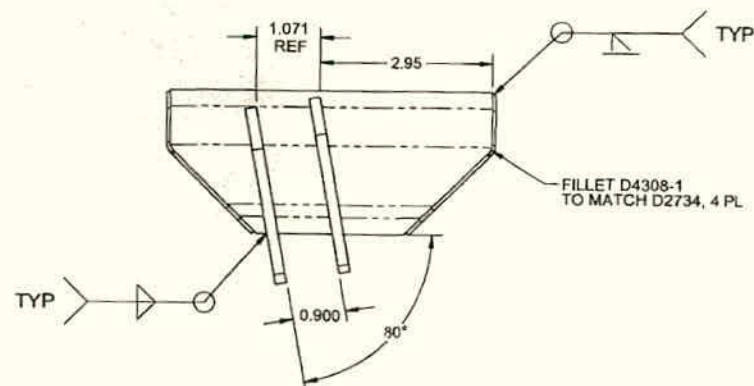
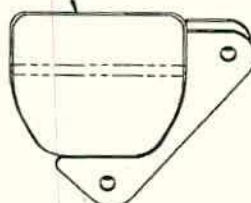
4



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



**D4308-041 STEP, LH CREW**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	CP	10.12.17
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.12.17			

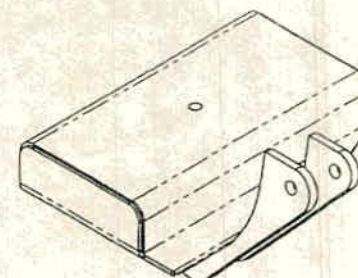
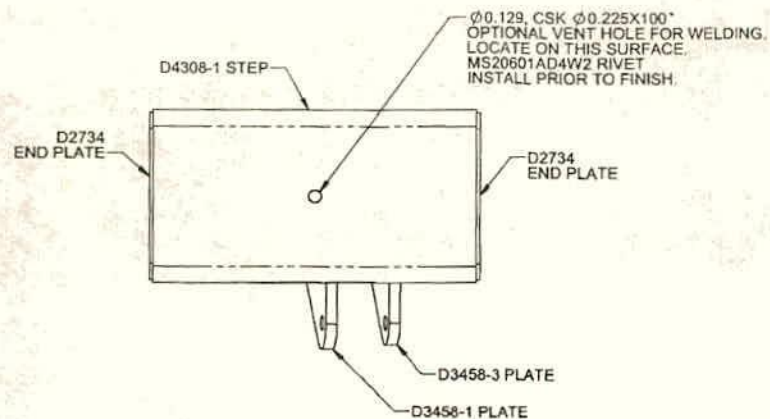
**RELEASED**  
2011-05-26

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

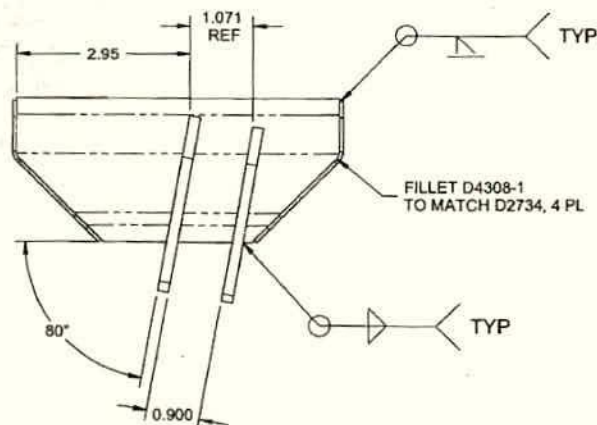
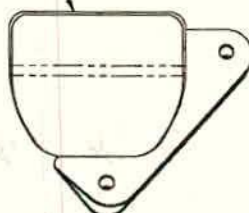
DRAWING NO. **D4308** REV. A  
TITLE **STEP, CREW** SCALE NTS

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ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



**D4308-042 STEP, RH CREW**

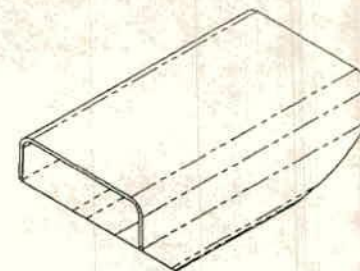
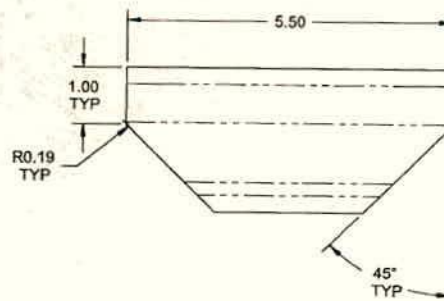
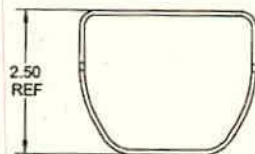
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4308</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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**RELEASED**  
2011-05-24  
JMT





98155

**D4308-1 STEP**

**RELEASED**  
2011-05-20  
JMD

- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.33 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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